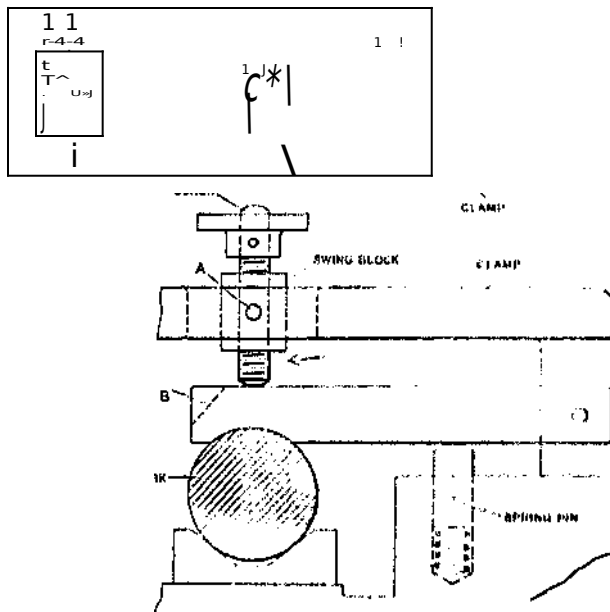


be tightened in the fixture with great rapidity. Fig. 60 shows a special nut for a box wrench, the purpose of which is to permit lifting the wrench off the "hex," and moving it back for a new grip. The round part of the nut serves to keep the wrench in place to be slipped back onto the hexagon nut, while the pin at the top of the nut makes the wrench an integral part of the fixture, so that it cannot get lost.

Two unusual examples of jig and fixture design are illustrated in Figs. 61 and 62. The distance that the clamp had to be



**Fig. 62. Quick-releasing Clamping Arrangement**

raised in removing the work from between the V's of these fixtures made it desirable to provide a new method of releasing the clamp more quickly than by turning the screw back

through the necessary distance. The way in which this was accomplished is clearly shown in the illustrations, and will be seen to consist of loosening the screw and then swinging the block which carries the screw on the pivot *A*, the direction being indicated by the arrow. This moves the screw off its bearing on